



PRODUCT DATA SHEET

9330 2K EPOXY PRIMER

PRODUCT DESCRIPTION:

A 2K chromate-free epoxy primer with outstanding anticorrosive properties. It combines the properties of a filling primer and an adhesion promoter. Resistant to extreme weather conditions as well as to severe chemical and mechanical stresses.

SUBSTRATES:

Steel, galvanized, stainless steel, aluminum, zinc.

SUBSTRATE PREPARATION:



Surfaces must be clean, dry, and free of rust, dust and grease.
Before the application use 9651 Silicone Degreaser.

APPLICATION: 1. SANDING PRIMER



Always wear protective equipment



Stir well before use



4 parts 9330
1 part of 9552 Epoxy Hardener



25% 9612



28 - 32 s
DIN 4 / 20°C (68°F)



Gravity spraygun nozzle
1.5 - 1.8
Pressure 1.7 - 2.2 bar
Film Thickness 2x = 80 - 120 µm



15 min / 23°C (73°F)



8 - 14 h / 23°C (73°F)
1 h / 60°C (140°F)
panel temperature



P 320 – P 400

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P 800 – P 1000



1K - 2K Paint Systems

APPLICATION: 2. WET ON WET PRIMER



Always wear protective equipment



Stir well before use



4 parts 9330
1 part of 9552 Epoxy Hardener



40 - 50% 9612



20 - 22 s
DIN 4 / 20°C (68°F)



Gravity spraygun nozzle
1.3 - 1.4
Pressure 1.7 - 2.2 bar
Film Thickness 2x = 40 - 50 µm



5 - 10 min / 23°C (73°F)



Final flash-off time
min. 2 - 3 h / 23°C (73°F)
max. 8 h before topcoat

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EQUIPMENT CLEANING:

After use, clean all equipment thoroughly with Nitro Thinner

TYPICAL PRODUCT DATA:

FLASH POINT: 13°C / 55°F

SPECIFIC GRAVITY: 1.54 g/cm³

SOLIDS CONTENT: 74%

THEORETICAL COVERAGE: 6 - 7 m² / l at 100 µm

VOC INFORMATION: 2004/42/IIIB(c) (540)540

COLOUR: GREY

PACKSIZE: 0.8L

STORAGE CONDITIONS: Store in cool place (5°- 25°C), avoid direct exposure to sunlight

SHELF LIFE: 24 months in tightly closed containers

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